

Date: Tuesday, 28/10/2008 9:56:32 AM  
User: Melanie Fauteux

## Process Sheet

DUPLICATE ① page

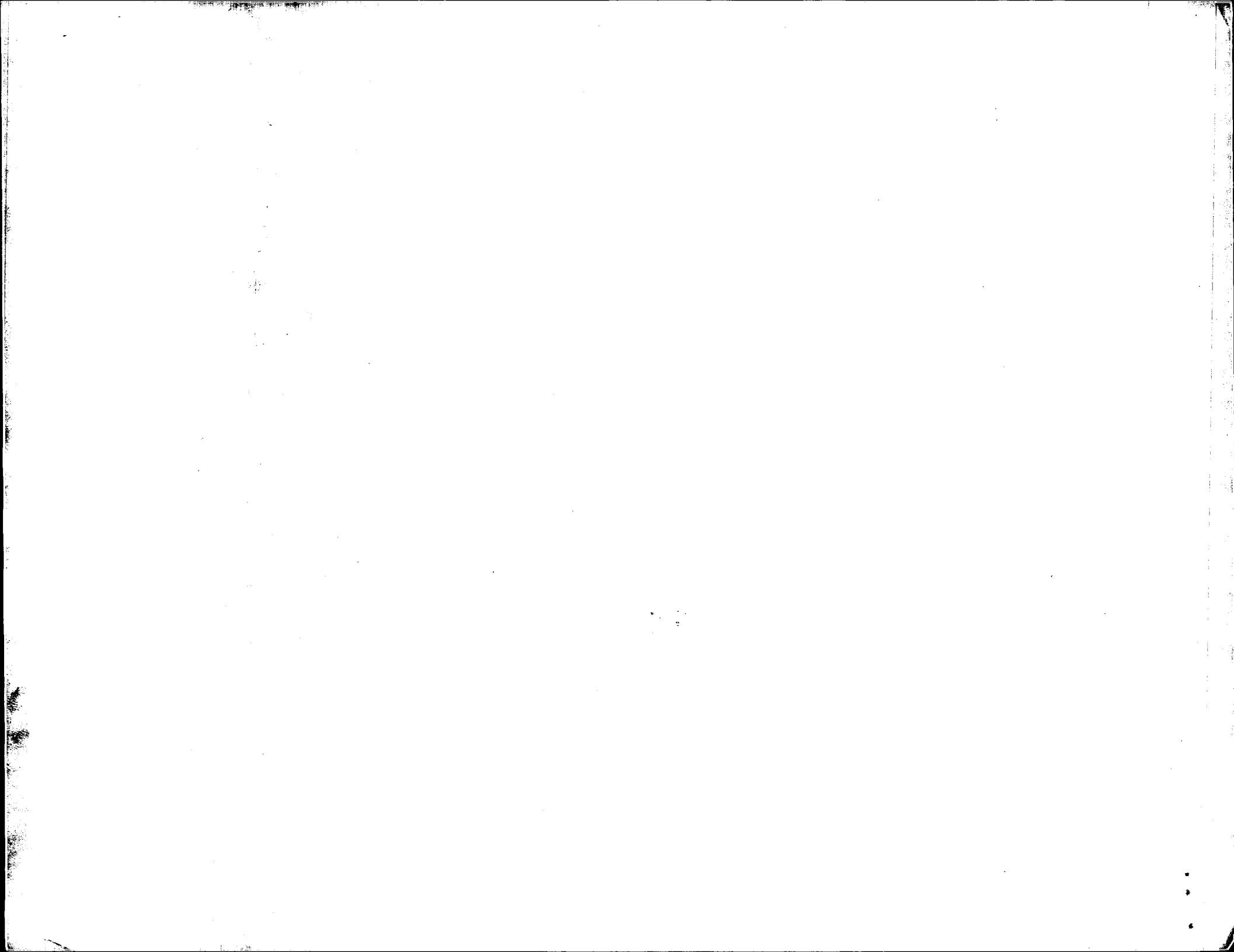
Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: STRUT		
Job Number	40009			Part Number	: D2565207		
Estimate Number	10959			Drawing Number	: D2565 REV E		
P.O. Number				Project Number	: N/A		
This Issue	28/10/2008	S.O. No.	:	Drawing Revision	: E		
Prsht Rev.	NC			Material	:		
First Issue	24/06/2008	Type	: SMALL /MED FAB	Due Date	: 07/07/2008 Qty: 10 Um: Each		
Previous Run	36516						
Written By							
Checked & Approved By	<u>MF 08-10-28</u>						
Comment	Est: D 01.08.28 Added Powder coat, and added Inspection level 3 and 21. SM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	108846 x 21 f/s
		Comment: Qty.: 1.8812 f(s)/Unit Total : 18.8118 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: 107518 x 27, 107688 x 4 f/s 8/08/08 10/27
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	So 08/08/21
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	PTO next page
		Comment: SMALL & MEDIUM FAB RESOURCE 1	So 08/08/28 (10)
4.0	QC5	INSPECT WORK TO CURRENT STEP	So 08/08/28 (10)
		Comment: INSPECT WORK TO CURRENT STEP	So 08/08/29 (10)
5.0	POWDER COATING	POWDER COATING	10X
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	M 1091 S2
	START TIME: OVEN TEMPERATURE: FINISH TIME:	3:15 OF 400 3:45	M.F 08/10/30



Date: Tuesday, 24/06/2008 10:58:33 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40009

Part Number: D2565207

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT

DL FL 08/10/31

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST253

DS 08/11/03 @

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/03 DS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-207 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: A Date: 08/11/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/27	3	I hat <del>was</del> <del>at</del> damaged dent	Initial 08/10/27 Poe Goto	Srip + destroy + replace qty @ 08/10/27 B2 H108846	SB 08/10/27	Initial 08/11/04 Poe Goto	08/10/28 Poe Goto	S 08/10/28
		Deep star for Shot on r.c material damaged						

NOTE: Date & initial all entries

**DART**COPY ISSUED  
BY DART

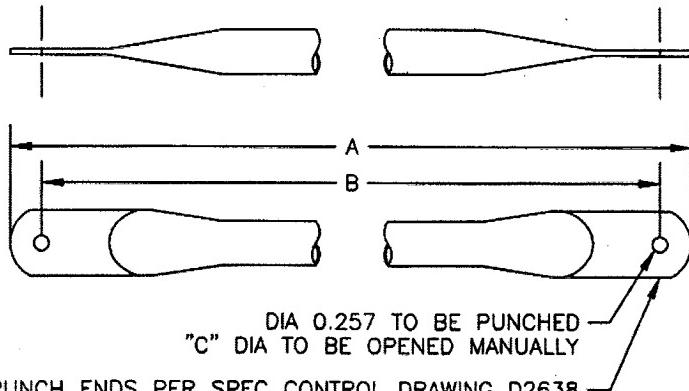
DESIGN	DRAWN BY	DART · AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1

DATE 04.05.05 TITLE STRUT SCALE 1:3

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D

**RELEASED**

04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

**GENERAL NOTES**

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF. DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

SHOP COPY

RETURN TO

ENGINEERING

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4 UNCONTROLLED COPY

3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT

4) ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

WORK ORDER

NO. 70001

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

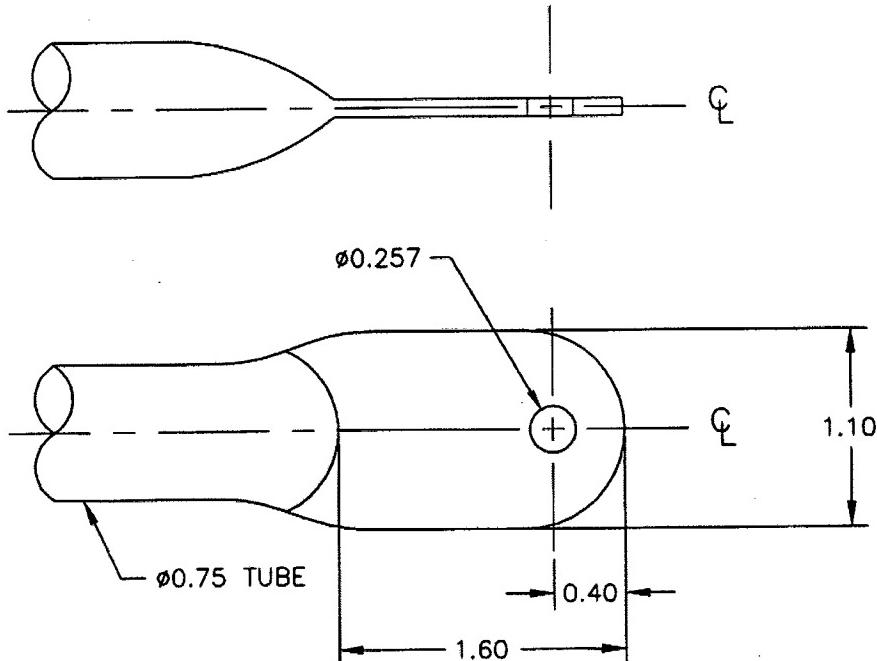
NOTE: Date & initial all entries

**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DMD	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

**RELEASED**  
48/05/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries